

# Work Order ID 51969

September 11, 2009 7:10:42 AM



Item ID: D2332-041

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 9/14/09

Start Qty: ~~12.00~~ <sup>20</sup>



Cust Item ID:

Required Date: 9/16/09

Req'd Qty: 12.00

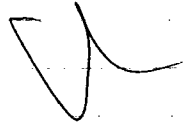


Customer:

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00



Small Fab

Memo

0.00

1- Cut D2332-7 and D2332-5 to length as per dwg D2332

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

110

0.00



Brake NC

Memo

0.00

Punch and form D2332-11 to length as per dwg D2332 using DT8012  
( need 2 per ass'y)

Brake NC

*M-k 09/09/14*

*20X*

*40 8*

*09/09/15*

*7.740*

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Date:

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Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

0.00



Small Fab

Small Fab

Memo

0.00

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459  
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

130

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

140

0.00



Large Fab

Large Fab

Memo

0.00

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)  
\*\*\*\*\*ensure nothing is inside of tube before welding\*\*\*\*\*

S.S Rod batch: 1109213

mk 09/09/16 20X  
x20 4  
x20 5  
x20 11  
x20 7

SY 09/09/22

# Work Order ID 51969

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Page 3

Item ID: D2332-041

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Start Date: 9/14/09

Start Qty: 12.00

Required Date: 9/16/09

Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

OK 09 09 22

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2010/09/23

2010/09/23

170

0.00



Small Fab

Memo

0.00

Small Fab

1- Tumble

2- Assemble as per dwg D2332

IB 9-9-24

M-H 09/09/24 (20X)

# Work Order ID 51969

September 11, 2009 7:10:43 AM



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Setup Start



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Stop



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Start Date: 9/14/09 Start Qty: 12.00



Cust Item ID:

Required Date: 9/16/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) S o r l o r l a s

W o r k e r  
f20

190



Packaging

Packaging

Identify as per dwg & Stock Location: 512

0.00

Memo

0.00

9/16/25 200 SP

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/09/25

mf 09-09-25

# Picklist Print

September 11, 2009 7:10:41 AM

Page 1

Work Order ID: 51969

Parent Item: D2332-041RevC1

Parent Item Name: Lid Prop Assembly 6.69" long



Comments:

Start Date: 9/14/09



Required Date: 9/16/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-4A  Bolt		Purchased	No			170	Each	149.0000	12.0000 			<del>X</del>

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	149	
101291	3	
106918	1	
108138	60	
111295 ✓	85	

AN960JD416L  Washer	Purchased	No				170	Each	958.0000	36.0000 			
--	-----------	----	--	--	--	-----	------	----------	--	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	958	
107008	54	
108138	4	
108583	42	
110153 ✓	458	
112492	400	

M-L 09/10/24

M111295 (20X)

M-L 09/10/24

M110153 (60X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 11, 2009 7:10:41 AM

Work Order ID: 51969

Parent Item: D2332-041RevC1

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 9/14/09

Required Date: 9/16/09

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304R.250 Purchased

No

100

f

24.6960

1.2632



304 SS Round bar .250

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

24.696

107387 ✓

24.696

M304TR0.500W.035 Purchased

No

110

f

218.0731

15.7895



304 RD Tube .500 x .035W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

218.0731097

108250

2.23

111097

24.687936

111704

31.6682737

112187 ✓

159.4869

M304TR1.000W.049 Purchased

No

100

f

61.5459

5.4316



304 RD Tube 1.00 x .049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

61.5459

108756

14.92

111457 ✓

46.6259

M-H 09/09/16

M107387

M-H 09/09/14

M112187

M-H 09/09/16

M111457

September 11, 2009 7:10:41 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Parent Item Name: Lid Prop Assembly 6.69" long

Comments:

Start Date: 9/14/09

Required Date: 9/16/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			170	Each	8,415.000	12.0000			



Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8415	
105938	36	
107499	5	
108145	36	
110450	1	
110507	184	
111827	5996	
112314 ✓	1972	
15924	0	
7690	24	
8182	41	
9629	120	

*Mk 09/09/24*  
*X*

*M112314 (20X)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

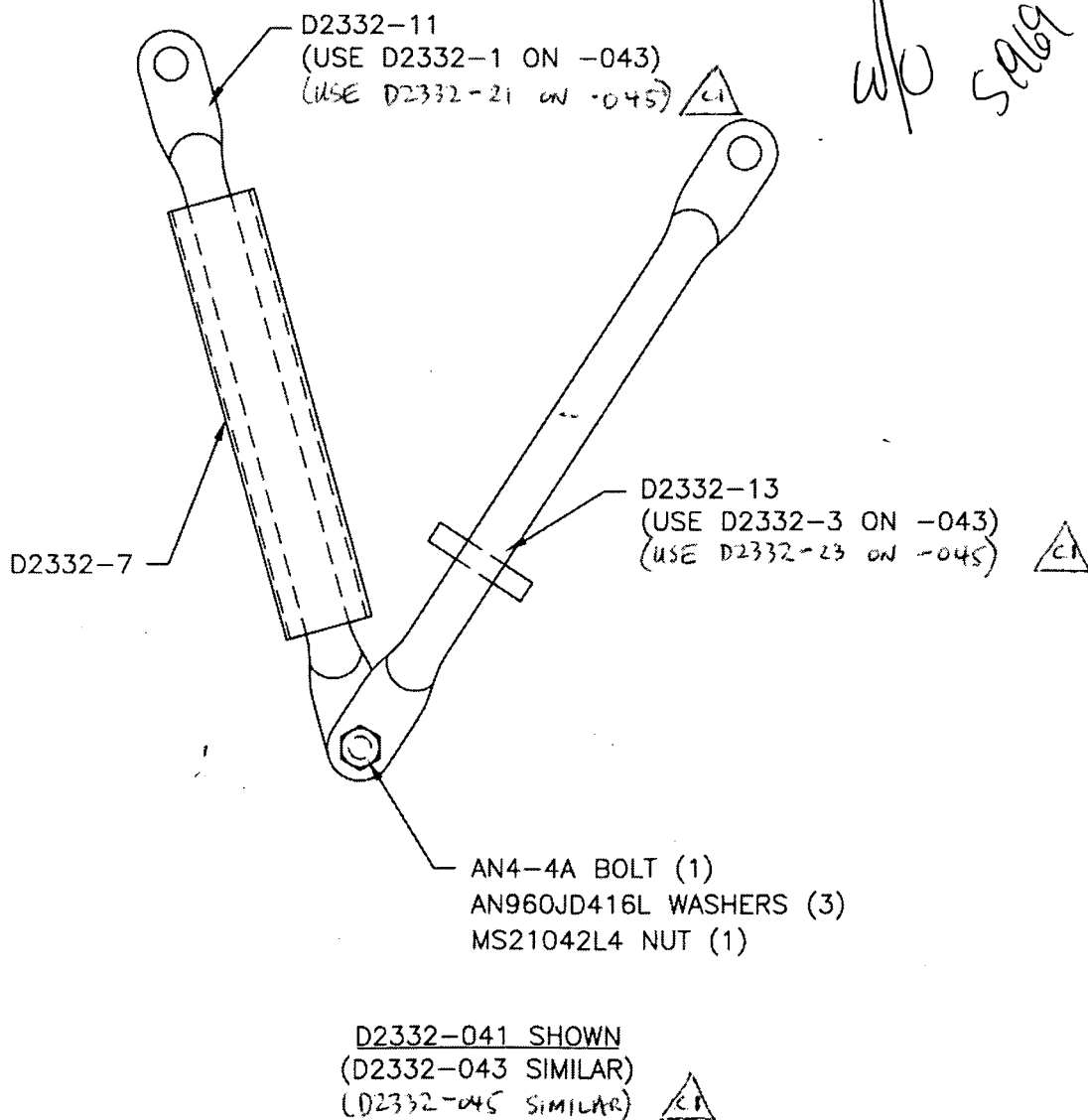
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	<i>[Signature]</i> 03.08.06	ADD -045 PROP (7.25" LONG)	



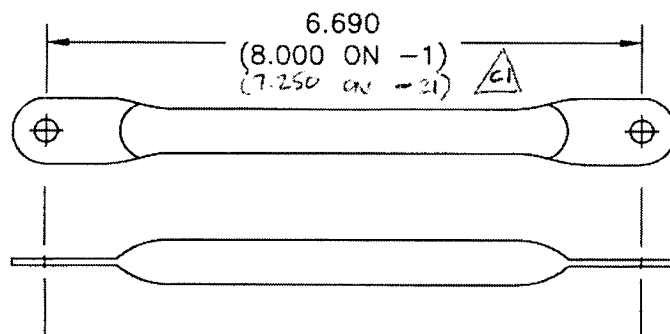
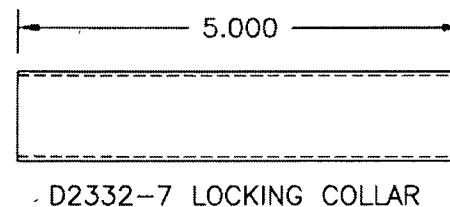
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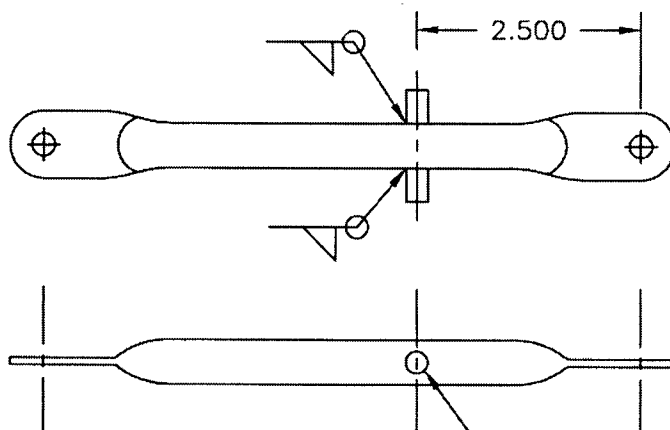
**DART**

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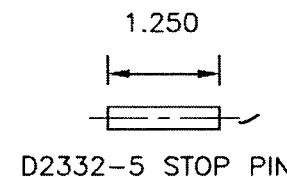
DESIGN	DRAWN BY	DART AEROSPACE LTD
C	03.07.03	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
03.07.03	03.08.06	D2332
DATE	TITLE	SCALE
03.07.03	LID PROP ASSEMBLY	1:2
		SHEET 2 OF 2
		REV. C



D2332-11 PROP  
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5



D2332-13  
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)  
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

CL

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

u/o 5/969